Work Order ID 73312 Wednesday, August 31, 2011 10:49:24 AM										P	Page 1
Revision ID:	D3536-23 Gasket		A	Accept				s	etup S		
Start Date: Required Date: Reference:	9/1/2011 9/15/2011	Start Qty: 16.00 Req'd Qty: 16.00			Cust Item I Customer:	D:					
Approvals:	Process Pla	n: MF	Date: -09 - 0/	Tooling: SPC (Y/N):		ite:		R		tart Stop	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty	t Reje Num	-
Draw Nbr	Rev	ision Nbr									-
D3536	Rev	A									
Waterjet FLOW CNC Waterje	ıt.	FLOW WATER JET Memo 1-Cut as pe Deburr if no	r Dwg D3536 ← (`Dwg Rev:_ ecessary	0.00 0.00 Prog Rev:	<u>A</u> D2-			Bu	<u>9-y</u>	<u> </u>	66)
QC Quality Control		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				K	19-2	FJ	

0.00 S wor/24

120 QC

Quality Control

QC8- Inspect parts - second check

Memo

Dart Ae	rospace	Ltd						•		₹;
W/O:			WC	RK ORDER CHA	ANGES					
DATE	STEP	PRO	OCEDURE CHAI	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No):	PAR #:	Fault Cate	gory:	NC	R: Yes	No DQA		Date: _	
	R	esolution:	Dispositio	n:	QA	NC CI	osed:		Date: _	<u>:-</u>
NCR:			WORK ORDI	ER NON-CONFO	RMANCE	(NCF	1)			
		Description of NC	Corrective Action Section				Verifica	cation	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign 8 Date	& Section C		Chief Eng	QC Inspecto

Work Order ID 73312

Page 2

Item ID:

D3536-23

Accept

Setup Start

Stop



Revision ID:

Item Name:

Start Date:

Gasket

Wednesday, August 31, 2011 10:49:24 AM

Required Date: 9/15/2011

9/1/2011

Start Qty: 16.00 Req'd Qty: 16.00

Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Operation

Description

Date:

Date:

Tooling: SPC (Y/N):

Set Up/

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

130

Packaging Packaging

Memo

Memo

Identify as per dwg & Stock Location 12-2

Run Hours

0.00

0.00

Tool ID

Tool # Plan Code

Date:

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Ae	erospa	ce Ltd
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W/O:		WORK ORDER CHANGES								
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DATE	STEP	Description of NC		ion B	Verification	Approval	Approval			
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
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Picklist Print

Wednesday, August 31, 2011 10:49:21 AM

Work Order ID: 73312

Parent Item: D3536-23

Parent Item Name: Gasket



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 16.00

Required Qty: 16.00

Comments:

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	583.5500	1.3365	23.76	35.		
										•	B11-9-)G	

NEOPRENE SHEET 0.063

Location	Loc Oty	Loc Code		
MAT052	583.55			7,\
117295	55.68		<u>.</u>	(Jb)
118026	127.87			
118663	400		1(8663	

Page 1

Dart Aeros	pace Ltd
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W/O:			WO	RK ORDER CHANC	ES					
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Resolution:		Disposition	n:	QA:	N/C Clo	sed:		Date: _		
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		Description of NC	Corrective Action Section				Verific	Verification	Approval	Approva
DATE	STEP	Section A	Initial Action Desc Chief Eng Chief En		Sign & Date			on C	Chief Eng	QC Inspecto
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DART AEROSPACE LTD	Work Order:	733/2
Description: Gasket	Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	S5.85	2		7 1301	
48.20	+/-0.030	48.70	Э		τ	
44.70	+/-0.030	44.76	>		T	
39.31	+/-0.030	39.31	7		τ	
33.92	+/-0.030	33.92	>		7	
28.53	+/-0.030	28.43	1	,	7	
23.14	+/-0.030	23.14	6		T	
17.75	+/-0.030	17.75	کی		7	
14.25	+/-0.030	14,35	>		7	
9.50	+/-0.030	9.50	۵.		ī	
4.75	+/-0.030	4.74	$ \forall $		4	
8.00	+/-0.030	8.00	1_		7	
16.00	+/-0.030	(6.00	\		7	
24.00	+/-0.030	24 WO	,		7	
32.00	+/-0.030	35.60	م ا	-	7	
39.00	+/-0.030	39.00	4		7	
48.00	+/-0.030	48.00	፠	<u>-</u>	7	
0.30	+/-0.030	,310	7		V 1302	
0.30	+/-0.030	.308	×		V	
1.89	+/-0.030	1.882			V	
Ø0.19	+0.005/-0.001	.191	2		V	

Measured by:		Audited by:	Prototype Approval:	N/A
Date:	11-9-29	Date: worlds	Date:	N/A

Rev	Date	Change	Revised by	Approx/ed
Α	07.03.14	New Issue	KJ/JLM	411
			7.17	

W/O:			W	ORK ORDER CHANGE	S				
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06.10.25

GASKET

06.10.25

NEW ISSUE

04.02.12

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D3536

DRAWING NO.

DART

AEROSPACE PORT HADLOCK,

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USA,

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26.65 23.15 - 21.15 17.65 13.40 0.90 9.15 - 5.65 1.89 3.90 DETAIL A Ø0.19 14.00

D3536-11 GASKET

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(TYP 3 PLS)

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	23.90	
DETAIL A #0.19 (TYP 4 PLS)	18.98 14.07 9.15 	1.89

D3536-13 GASKET

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PURPOSE

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COPIED

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ©
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

Dart Aerospace Lt

W/O:			WO	RK ORDER CHANGES	3				
DATE STEP		PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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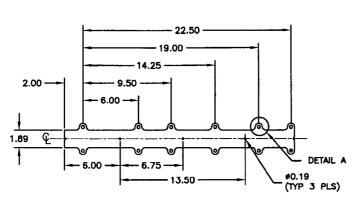
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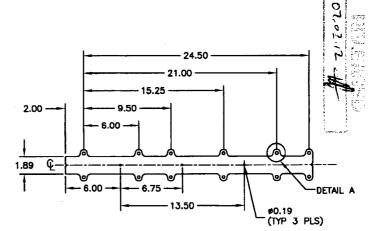
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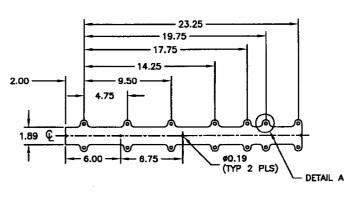


D3536-33 GASKET

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NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT &
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 OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



D3536-35 GASKET

CHECKED 37	APPROVED	D3536 SHEET
DATE		TIME TO THE
06.10.25		GASKET

BNWWD BY

DART AEROSPACE

USA,

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D3536-41 GASKET

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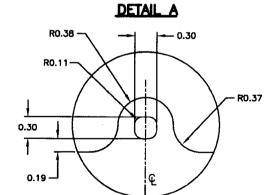
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PURPOSE

욹 COPIED

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